

Date: Tuesday, 23/10/2007 11:24:36 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SCUFF PLATE
<b>Job Number</b> :	32855		
<b>Estimate Number</b> :	11946		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D206555002
<b>This Issue</b> :	23/10/2007	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D206-555 REV C
<b>First Issue</b> :	11/06/2007	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	32855	<b>Drawing Revision</b> :	C
		<b>Material</b> :	N/A
<b>Written By</b> :		<b>Due Date</b> :	18/06/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	10
<b>Comment</b> :	est rev C 99.06.29 returned to electro polish DM Est Rev:D Now on Waterjet 07-06-11 JLM		

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL  
Type Labels as per PPP D206-555-002

2.0	M304S25GA	304/316 .020" Sheet
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**Comment:** Qty.: 0.3591 sf(s)/Unit Total: 3.5910 sf(s)  
304/316 .020" Sheet  
BATCH: M103504

SAD 07-06-11

10

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D206-555  
Dwg Rev: C  
Prog Rev: C

2-Deburr if necessary

SAD 07/06-11

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07-06-11

10

5.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

SAD 07/06/11 (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 8/11/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/10/2007 11:24:36 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 32855

Part Number: D206555002

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

07/10/23 (3) FF 07-10-18 (3) FF 07-10-23 (3)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8315-2

Remove tooling tabs and deburr

- Polish

FF 07-10-18 (3)

FF 07-10-23 (3)

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 4886

Possible supplier: TQF Technologies

07/11/24 (8)

(3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

07/11/02 (8)

10.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

07/11/05 (8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/11/5

(8x)

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/05

Job Completion





07/11/05

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/18	7	Split u/o	SB	07/10/18	5		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/18	80	FINISH NOT ADDED TO OW 3 SCUFF PLATES OUT OF 5.		Re-polish			07/10/18 	

NOTE: Date & initial all entries

**DART**

DESIGN JB	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

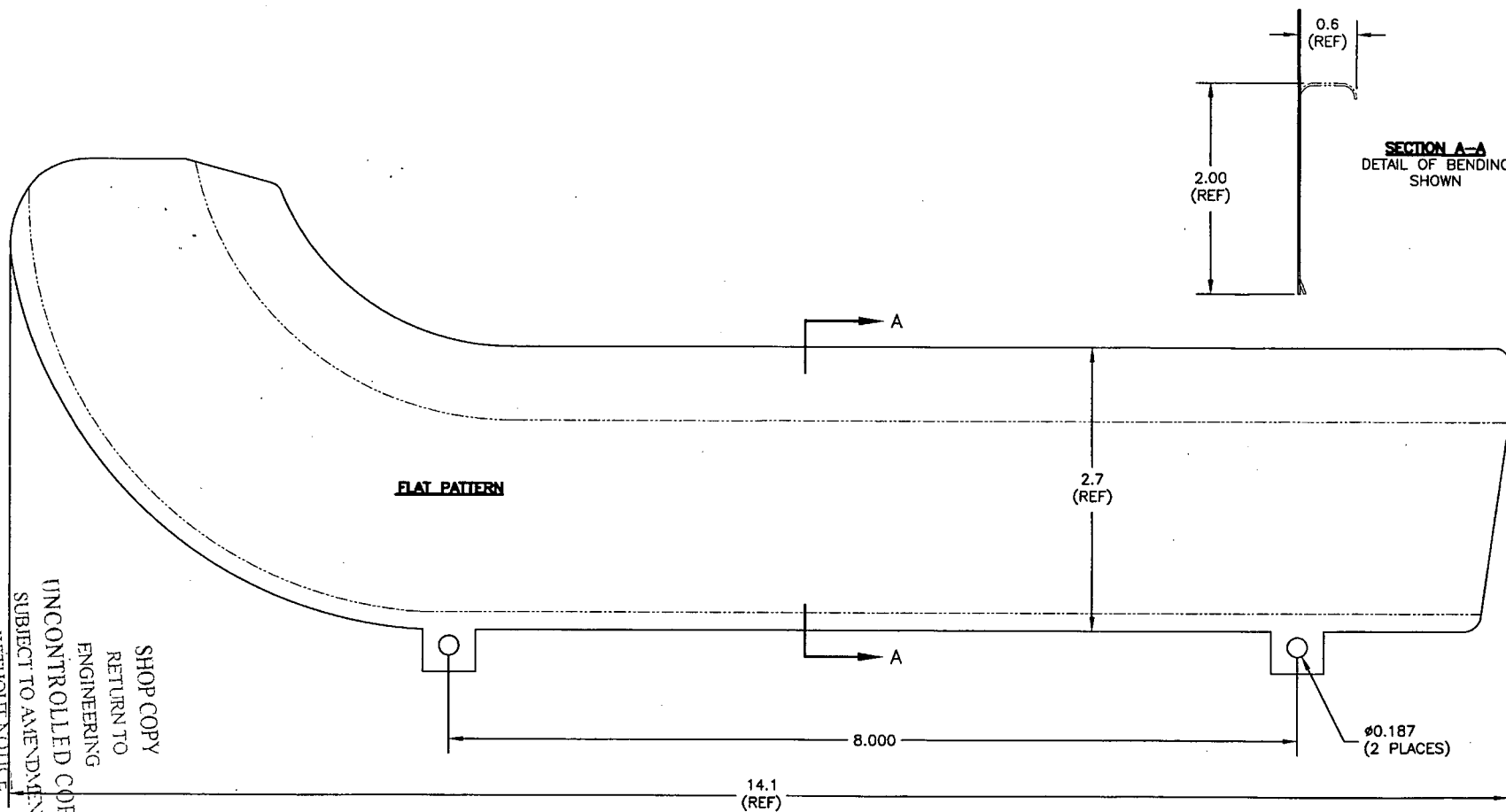
QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

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06.09.19  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32855*

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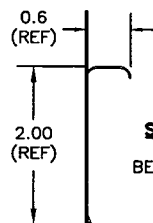
**SECTION A-A**  
 DETAIL OF BENDING  
 SHOWN

RELEASED  
 06.09.19

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)  
 D206-555-002 (BEND OPPOSITE)

- NOTES**
- 1) BEND PER M/F TEMPLATE D206-555-T1
  - 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
  - 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



**SECTION C-C**  
DETAIL OF  
BENDING SHOWN

**DETAIL B**  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

2.7  
(REF)

**FLAT PATTERN**

8.000

19.0  
(REF)

8.000

Ø0.187  
(3 PLACES)

**RELEASED**

06.09.19-11

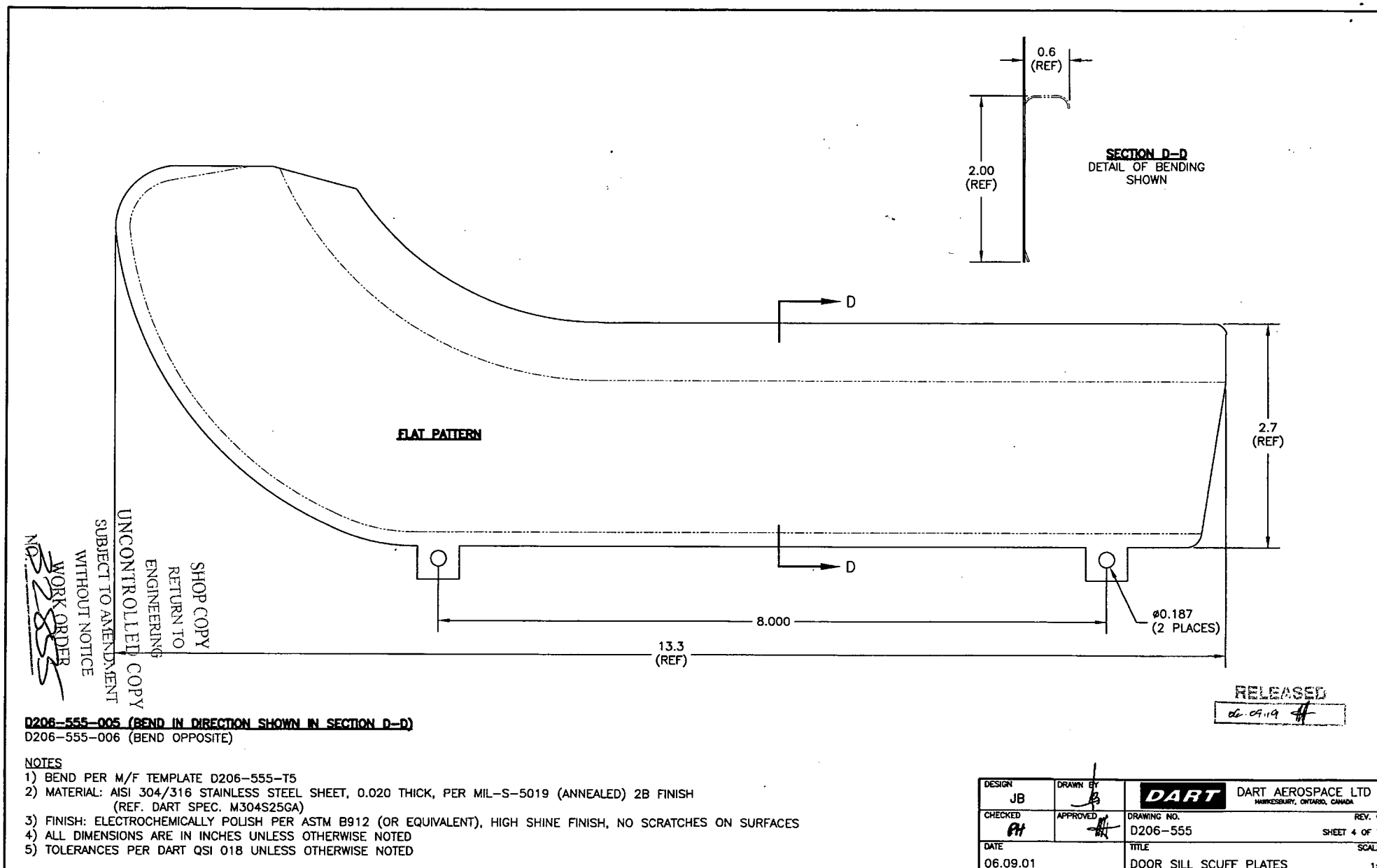
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WORK ORDER  
NO. 52855

**D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)**  
**D206-555-004 (BEND OPPOSITE)**

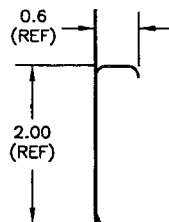
**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

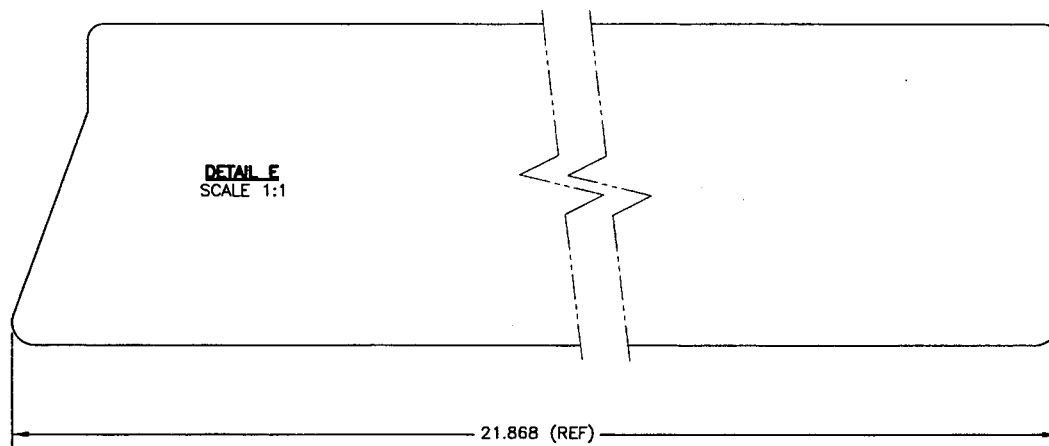
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 3 OF 7 SCALE 2:3





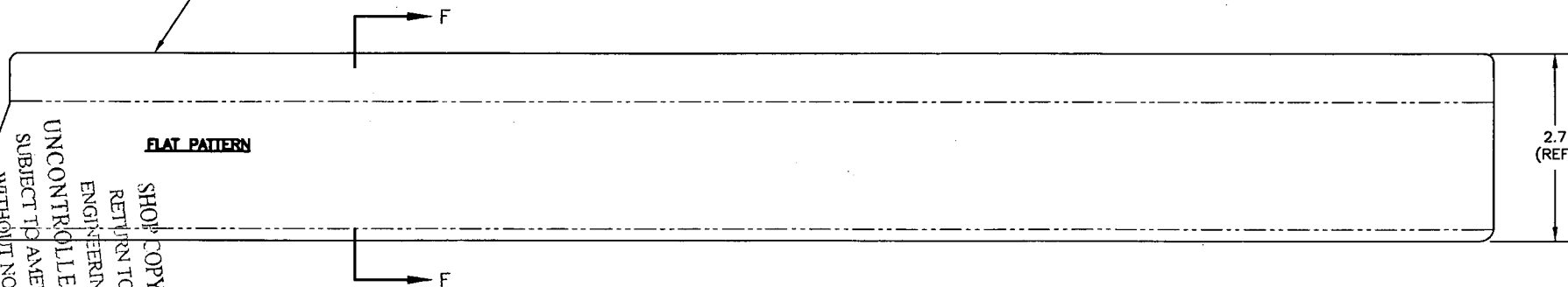


**SECTION F-F**  
DETAIL OF  
BENDING SHOWN



**DETAIL E**  
SCALE 1:1

REFER TO DETAIL E  
FOR 1:1 SCALE



**FLAT PATTERN**

NO. 32855  
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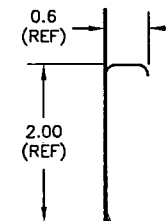
06.09.19

**D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD WINDYBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED H	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



**SECTION H-H**  
DETAIL OF  
BENDING SHOWN

REFER TO DETAIL G  
FOR 1:1 SCALE

**DETAIL G**  
SCALE 1:1

16.000 (REF)

H

18.9  
(REF)

**FLAT PATTERN**

8.000

H

8.000

Ø0.187 (TYP 3 PLACES)

**RELEASED**

06.09.19

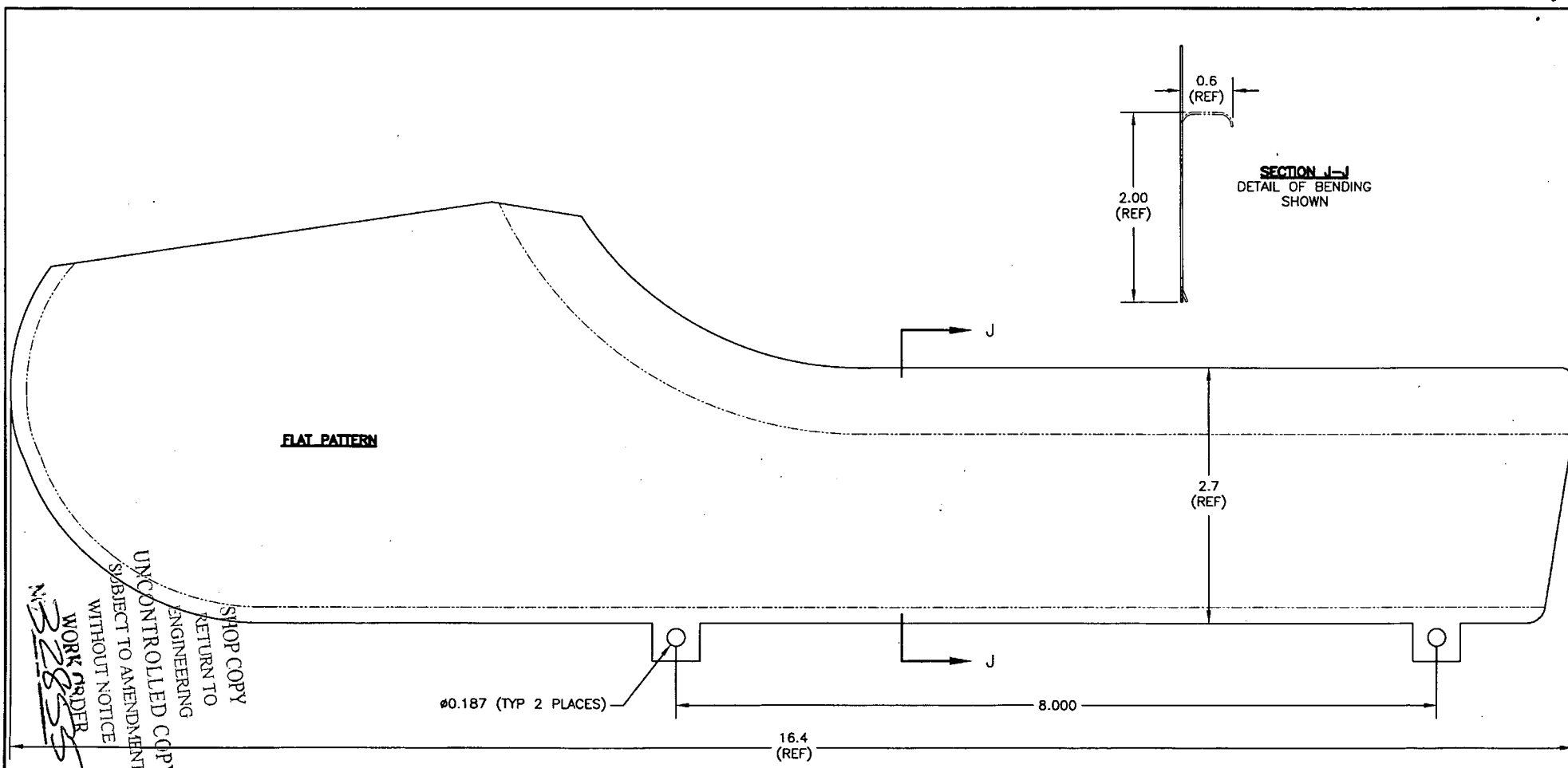
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**D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MIDLANDS, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)  
D206-555-012 (BEND OPPOSITE)

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.19

DESIGN <b>JB</b>	DRAWN BY <i>[Signature]</i>	<b>DART</b> DART AEROSPACE LTD MUNICIPALITY, ONTARIO, CANADA	REV. C
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 7 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1



DART AEROSPACE LTD		Work Order: <del>320</del> 32 767
Description: <u>Scaff PLATE</u>		Part Number: <u>D206555002</u>
Inspection Dwg: <u>D206555</u> Rev: <u>C</u>		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 14.01	+/- 0.030	14.00	✓		M-T	
B 8.00	+/- 0.020	7.998	✓		Vern	
C Ø0.187	Ø $\frac{+0.005}{-0.004}$	Ø0.190	✓		Vern	
D 0.020	+/- 0.010	0.027	✓		Vern	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <u>SAO</u>	Audited by: <u>Ep</u>	Prototype Approval:	N/A
Date: <u>07/06/11</u>	Date: <u>07/06/18</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	



# Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: November 1, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

**C121120**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
132319		<b>NO. DE COM./P.O.#</b> 4886	
	8	D206-555-002 ✓ CUST. REF.:B32855	ELECTROPOLISH PER ASTM B912 REV.02
	8	D206-555-007 CUST. REF.:B32909	
	9	D206-555-009 CUST. REF.:B32767	

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.




Raj Thakoordeen

Total Quality Finishing